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RBW6500X01611-W142E-3T

Job Sheet 200725



Part No: RBW6500X01611-W142E-3T **Job Qty:** 1 pcs

Part Name: Oil Seal Housing Removal Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 11/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6500X01611-W142E-3T REV 4 IPP Rev. A 19.04.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/4/19		0.25	0.25	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		GP 19-10-22
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	11/4/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		OCT 23 2019 40-89
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/4/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DA:
				Packaging 3 - 7 - B4B	21
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	11/4/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 100 - (Small Fab) Assemble as per drawing.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90695A038	Jam Nut M6 X 1 (Mcmaster)	2 Ea (2 ea)	100-Small Fab - 1	012578
91005A033	Flange Nut M6 X 1 (Mcmaster)	2 Ea (2 ea)	100-Small Fab - 1	201120
93210A016	Threaded Stud M6X 50	2 Ea (2 ea)	100-Small Fab - 1	201121
RBW6500X01611-W142E-3T-11	Screw Weldment	1 pcs (1 ea)	100-Small Fab - 1	216734
RBW6500X01611-W142E-3T-19	Long Stud	2 pcs (2 ea)	100-Small Fab - 1	214784
RBW6500X01611-W142E-3T-3	Cross Bar	1 pcs (1 ea)	100-Small Fab - 1	209096
RBW6500X01611-W142E-3T-5	Extractor	4 pcs (4 ea)	100-Small Fab - 1	263394
RBW6500X01611-W142E-3T-7	Large Seat	1 pcs (1 ea)	100-Small Fab - 1	26954
RBW6500X01611-W142E-3T-9	Small Seat	1 pcs (1 ea)	100-Small Fab - 1	210444
				209637

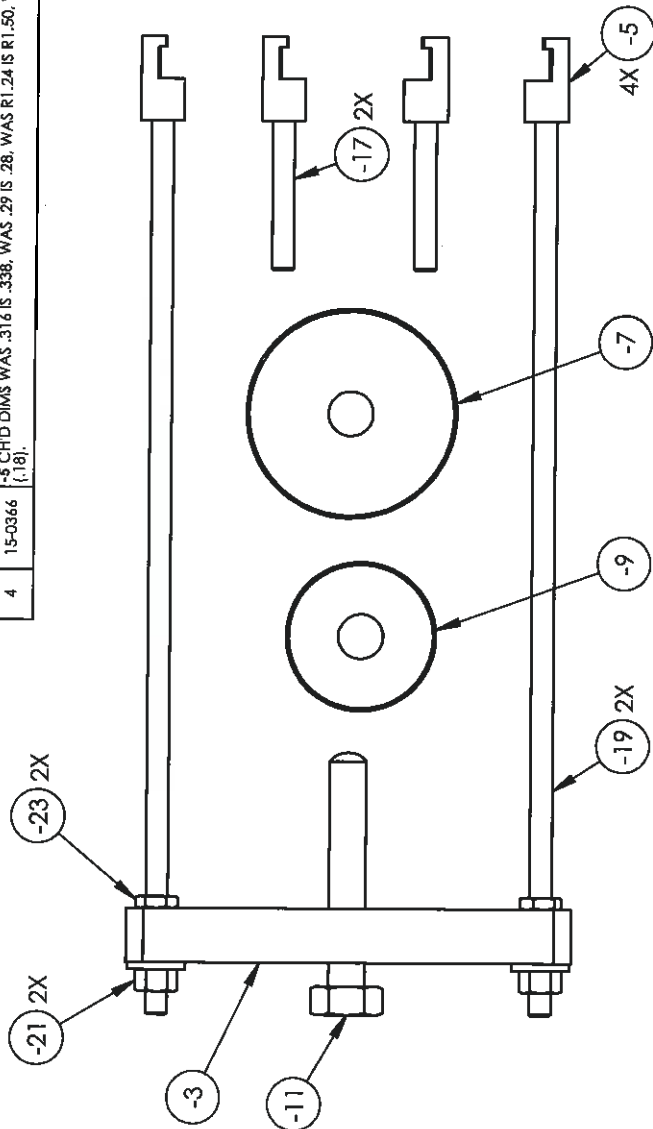
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90695A038	2	100	0
	91005A033	2	2	0
	93210A016	2	2	0
	RBW6500X01611-W142E-3T-11	1	0	0
	RBW6500X01611-W142E-3T-19	2	12	0
	RBW6500X01611-W142E-3T-3	1	6	0
	RBW6500X01611-W142E-3T-5	4	24	0
	RBW6500X01611-W142E-3T-7	1	6	0
	RBW6500X01611-W142E-3T-9	1	6	0
Part Specifications				
Specifications could not be found.				

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 CHD OD WAS Ø.749 IS Ø.74, CHD M6 X 1 THREAD DEPTH WAS .434 IS MIN. DEPTH .43. -9 CHD TOLERANCE WAS Ø.460 IS Ø.46.	7/31/13	RJC	GE
1	14-0215	-3 CHD ENGRAVE NOTE WAS "RBW6500X01611-W142E-3T" IS T/N. -5 CHD DIAMETER WAS Ø.74 IS 473. CHD SLOT WAS .501 IS .316 CHD TIP WAS .184 IS .116. CHD RADIUS WAS R1.240. CHD LENGTH WAS 1.443 IS .911. -13 ADDED DWG. -19 ADDED DWG. CHD FROM B/O TO MANUFACTURED PART.	11/12/14	RJC	JAG
2	15-0011	UPDATED DRAWING TO NEW STANDARDS. -5 CHD M6X1.0 HOLE DEPTH WAS .43 IS .35.	1/12/2015	RJC	JAG
3	15-0128	-3, -7, -9 & -19 MATERIAL CHD WAS 1018 IS 1018/1020. -7 CHD ENGRAVE NOTE WAS "RBW6500X01611-W142E/2-3T" IS P/N. -9 CHD ENGRAVE NOTE WAS "RBW6500X01611-W142E/3-3T" IS P/N. -13 CHD DIM WAS SR .27 IS SR .25.	6/4/2015	RJC	JAG
4	15-0366	-5 CHD DIMS WAS .316 IS .338, WAS .29 IS .28, WAS R1.24 IS R1.50, WAS (.087) IS (.078), WAS (.20) IS (.18).	11/20/2015	RJC	JAG



200725 MJS
19-09-17

NOTE:
1. PART OF KIT RBW6505G00331-3T.

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-3	1	CROSS BAR	1018/1020		2
		-5	4	EXTRACTOR	4140 Q&T/4142 Q&T		3
		-7	1	LARGE SEAT	1018/1020		4
		-9	1	SMALL SEAT	1018/1020		5
X		-11	1	SCREW WELDMENT			6
1		-13		THREADED ROD	STEEL	M10 X 1.5 X 70mm (MCMASTER-CARR #99055A231) MODIFIED	7
1	B/O	-15		HEX NUT	STEEL	M10 X 1.5mm (MCMASTER-CARR #90685A046)	6
	B/O	-17	2	SHORT STUD	STEEL	M6 X 1 X 50mm (MCMASTER-CARR #93210A016)	1
		-19	2	LONG STUD	1018/1020		8
	B/O	-21	2	FLANGE NUT	STEEL	M6 X 1 (MCMASTER-CARR #91005A033)	1
	B/O	-23	2	JAM NUT	STEEL	M6 X 1 (MCMASTER-CARR #90695A038)	1
ASSY -11							

DART
AEROSPACE

OIL SEAL HOUSING REMOVAL PULLER

DWG NO.	RBW6500X01611-W142E-3T	REV	4
MAT'L		DRAWN BY:	CLOUGH
UNLESS OTHERWISE SPECIFIED		APPROVED	D. Weil
DIMENSIONS ARE IN INCHES		HEAT TREAT	
FRACTIONS ± 1/8		FINISH	
ANGLES ± .5°		SPEC	
1. BREAK ALL SHARP EDGES .015 X 45°			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:2	DATE	11/3/2014
			AW139
			SHEET 1 OF 8



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
		MRB (QS1042)			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				